

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011504**Date Inspected:** 17-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** LI Yang, Luan Zhao Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**OBG # TRIAL ASSEMBLY YARD (6AW)**

This QA inspector performed Magnetic Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Deck panel diaphragm. The weld designations reviewed are as follows.

SSD10-PP38-003~004

Nondestructive testing (NDT) notification No. 005072

This QA Inspector randomly observed the following work in progress:

This QA inspector observed, ZPMC qualified welding personnel identified as 045221 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA029-004 Repair (6AW CA longitudinal Corner weld), The Critical Welding Repair Report (CWR) was B-CWR1058. ZPMC CWI identified as Mr.Luan Zhao Gang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1

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## WELDING INSPECTION REPORT

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This QA inspector observed, ZPMC qualified welding personnel identified as 067665 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SSD16-PP39-170, ZPMC CWI identified as Mr. LI Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-B-U2-FCM-1

This QA inspector observed, ZPMC qualified welding personnel identified as 068091 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP610-001-040, ZPMC CWI identified as Mr.Luan Zhao Gang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1

This QA inspector observed, ZPMC qualified welding personnel identified as 053742 perform Flux Core Arc Welding (FCAW), weld joint identified as OBE7B-003, ZPMC CWI identified as Mr. LI Yang.. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-B-U2-F-3

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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